

Work Order ID 86718

86718

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July-06-12 11:42:41 AM

Item ID: D2279 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Spacer
 Start Date: 7/06/12 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: Date: 12-09-17 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					(87)			
D2279	Rev D								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D 2279 Dwg Rev: <u>0</u> Prog Rev: <u>0</u> 2-								
2024 . 046	Debur if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

5mb
12-7-23

DAS
16

214/25

(27)

B2-7-24

B2-7-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo Form As per Dwg D2279	0.00 0.00				27			JT 12/08/15
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				27			(DAS) 12/8/15 12/08/15 count
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				27			7/6 12-8-16

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<u>12/18/16</u>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo	0.00 0.00							<u>12/08/16</u>
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>MLJ 12/08/16</u> <u>MLJ 12/08/16</u>

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Picklist Print

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Work Order ID: 86718

Parent Item: D2279

Parent Item Name: Step Spacer

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev: A New Issue 05-11-07 JLM
IPP Rev: B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	178.1612	0.147	3.7136832	4	1812-7-24	

Location

Loc Qty

Loc Code

MAT022

178.1611626

120605

49.6627416

121197

32.498421

122136

96

122136

27

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DART

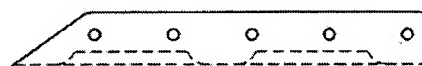


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. D
BW	CP		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
KE	MP	D2279	
DATE	TITLE	SCALE	
98.10.05	STEP SPACER	1:2	
A	94.10.13	NEW ISSUE	
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881	
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912	

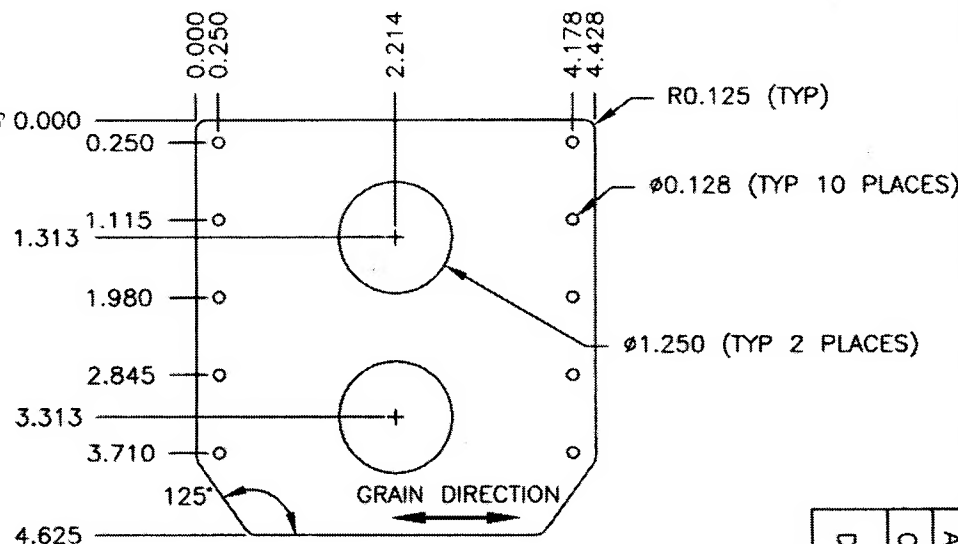
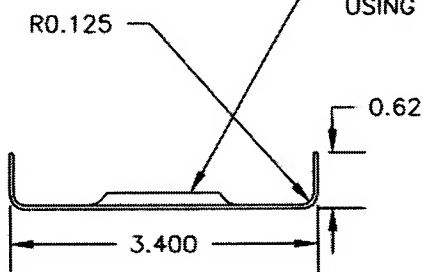
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98.10.08 DS

UNDER REVIEW

DESIGN 15 GP
DESIGN 15 GP BUT CHECK WITH
TS BEFORE MANUFACTURE
OK 4/4/03

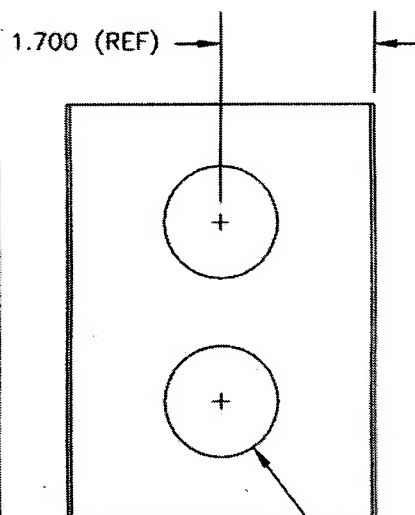


FLANGE AFTER BENDING
TOWARDS INSIDE OF PART
USING DT8174 (2 PLACES)



FLAT LAYOUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 96718



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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